



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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S. Healey

D2574
Job Sheet 191028



Part No: D2574

Job Qty: 12 pcs

Part Name: Saddle, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description:

Note: DWG REV F IPP Rev: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis <i>B4B</i>	12 pcs	3/18/19		1.21	18.75	HAAS - 1		<i>SBL 19/04/27</i>
							HAAS - 2		
							HAAS - 3 <i>B4B</i>		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	3/18/19		0.00	1.50	Conventional Mill - 1 - B4B		<i>SBL 19/05/02</i>
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	3/18/19		0.00	0.00	QC 2 - 1		<i>VH8 19/05/16</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Container No: S176069



Part: D2574

Job No: 191028

Serial No/Batch: S176069

Revision: Rev.F

Inspector:

Exp Date:

Instructions: D2574 Rev C, sheets 1-3 Date: 04/29/19

					QC 2 - 56					
					QC 2 - 57					
					QC 2 - 62					
					QC 2 - 63					
					QC 2 - 8					
					QC 2 - 66					
					QC 2 - 64					
					QC 8 - 12					
					QC 8 - 14					
					QC 8 - 17					
					QC 8 - 20					
					QC 8 - 25					
					QC 8 - 3					
					QC 8 - 32					
130 QC 8	12 pcs	3/18/19	0.00	0.00	QC 8 - 33					
					QC 8 - 35					
					QC 8 - 39					
					QC 8 - 4					
					QC 8 - 44					
					QC 8 - 45					
					QC 8 - 49					
					QC 8 - 58					
					QC 8 - 8					
					QC 8 - 9					
					QC 8 - 68					
					QC 8 - 67					
					QC 8 - 1 (A)					
					QC 8 - 47					
140 Handfinish - 1-1 Chemical-B4B	12 pcs	3/18/19	0.00	0.48	Handfinish - 1 - 1 - B4B					
					Handfinish - 1 - 2 - B4B					
					Handfinish - 1 - 3 - B4B					
					Handfinish - 1 - 4 - B4B					
					Handfinish - 1 - 5 - B4B					
					Handfinish - 1 - 6 - B4B					
					Handfinish - 1 - 7 - B4B					
					Handfinish - 1 - 8 - B4B					
					Handfinish - 1 - 9 - B4B					
					Handfinish - 1 - 10 - B4B	D.R/19/05/06				
					Handfinish - 1 - 11 - B4B					
					Handfinish - 1 - 12 - B4B					
					Handfinish - 1 - 13 - B4B					
					Handfinish - 1 - 14 - B4B					
					Handfinish - 1 - 15 - B4B					
					Handfinish - 1 - 16 - B4B					
					Handfinish - 1 - 17 - B4B					
					Handfinish - 1 - 18 - B4B					
					Handfinish - 1 - 19 - B4B					
					Handfinish - 1 - 20 - B4B					
					Handfinish - 1 - 21 - B4B					

				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	3/18/19	0.00	0.39	Powdercoat - 1 - B4B
						Powdercoat - 2 - B4B
						Powdercoat - 3 - B4B
						Powdercoat - 4 - B4B
160	QC 3	12 pcs	3/18/19	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 26
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 6
						QC 3 - 68
						QC 3 - 9
						DAS MAY 06 2019 40 9-89
170	Packaging 3-1 - Stock - B4B	12 pcs	3/18/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21 MAY 07 2019

Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. 516669 1-Machine Step No 1 per Folio FA051 and inspect
 Descriptions: per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 110 - (Manufacture as per dwg) Machine keyway as per dwg D2573 & D2574
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis	5166696

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-005	12	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Aft Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Aft Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Aft Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Aft Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Aft Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Aft Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Aft Inboard	1.365Inches + 0.010 - 0.000	1.375 1.365		
14	Saddle, Aft Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Aft Inboard	4.119Inches + 0.010 - 0.000	4.129 4.119		
16	Saddle, Aft Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Aft Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Aft Inboard	0.240Inches + 0.020 - 0.000	0.260 0.240		

19	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Inboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Aft Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Inboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

Plex 2/20/19 2:58 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order: 191 028
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.498	0.495	0.500	0.499		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.499	0.500	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.125	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.133	0.133	0.130		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.252	0.252	0.252	0.251		
S	0.115	0.135		0.130	0.131	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.242	0.243	0.244		
W	0.115	0.135		0.132	0.135	0.134	0.133		
X	0.307	0.312		0.310	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.365	0.361	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.623	0.624		
AC	0.053	0.073		0.055	0.068	0.065	0.066		
AD	0.240	0.260		0.252	0.252	0.252	0.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.132	0.130	0.130	0.135		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.251	0.252	0.252	0.252		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBC
Date: 19/04/29

Audited by: A.F.
Date: 19-05-06

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 19/028
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		0.495	0.498	0.500	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.375		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.569	0.568	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.133	0.131	0.130	0.130		
Q	0.115	0.135		0.124	0.125	0.125	0.125		
R	0.240	0.260		0.251	0.252	0.252	0.25		
S	0.115	0.135		0.131	0.131	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.250		
V	0.230	0.250		0.242	0.243	0.243	0.243		
W	0.115	0.135		0.133	0.130	0.131	0.132		
X	0.307	0.312		0.312	0.310	0.312	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.362	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.624	0.624		
AC	0.053	0.073		0.068	0.065	0.065	0.064		
AD	0.240	0.260		0.252	0.252	0.253	0.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.265	0.265		
AH	0.240	0.260		0.252	0.252	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.034	0.033	0.033	0.033		
Accept/Reject									

Measured by: V/H	Audited by: B-a
Date: 19/5/11	Date: 19-05-06

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 191028
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.000		
F	0.490	0.510		0.5003	0.502	0.501	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.5015	0.5015	0.503	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.5685	0.569	0.570	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.131	0.131	0.131	0.131		
Q	0.115	0.135		0.125	0.126	0.126	0.125		
R	0.240	0.260		0.252	0.2515	0.251	0.250		
S	0.115	0.135		0.131	0.133	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.243	0.243	0.239	0.243		
W	0.115	0.135		0.129	0.131	0.130	0.132		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.363	0.363	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.254	0.249	0.253		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.250	0.250	0.250	0.250		
AH	0.240	0.260		0.251	0.250	0.250	0.245		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	VHJ
Date:	19/5/11

Audited by:	MA
Date:	19-05-06

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	